

Work Order ID 66000 -2

Tuesday, February 01, 2011 12:55:07 PM

Ship Monday 07/12 301 Mill + 1000 Supply Alone D3391-023



Page 1

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 2/1/2011

Start Qty: 6.00

Required Date: 2/4/2011

Req'd Qty: 6.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: 2 Prog
Rev: 1 2-Deburr if necessary

B11-2-2



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-2-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulostor



Work Order ID 66000

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Page 2

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Stop

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 11/02/07

140



QC

Quality Control

QC'S- Inspect part completeness to step on W/C

0.00

Memo

0.00

Ensure joggle as per dwg D3429

8/1/02/07

HL

150



Large Fab

Large Fab

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
M116787 Weld hardcoat as per Dwg D3437

EL

11-2-17

(X8)

Work Order ID 66000

Tuesday, February 01, 2011 12:55:07 PM



Page 3

Item ID: D3564-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/1/2011 Start Qty: 6.00

Required Date: 2/4/2011 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00 - Inspector is attaching Retal



0.00 25 uloz118 slat (S)

QC

Memo

Quality Control

8

71102

170

QC5- Inspect part completeness to step on W/O

0.00



0.00 Sularice (S)

QC

Memo

Quality Control

180

Grey Sandtex(Ref:4,3,5,6) per QSI005 4,3

0.00



0.00

Powdercoat

Memo

Powder Coating

START TIME: 11:35
300° FINISH TIME:

OVEN TEMPERATURE:
12:05

8

BR 14-2-23

Work Order ID 66000

Tuesday, February 01, 2011 12:55:07 PM

Page 4

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 2/1/2011 Start Qty: 6.00

Required Date: 2/4/2011 Req'd Qty: 6.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: FP

0.00

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Engineer in approval
Please, AL

MUF 11-02-24

11/02/24 AL

POSITIVE
RECALL

POSITIVE RECALL

EFFECTIVE 11-02-17 AUTH AL

RELEASED AL DATE 11-02-23

FOR TRIBEAM USE
ONLY.

NOT FOR FALCON

AVIATION.

11/02/23

Picklist Print

Tuesday, February 01, 2011 12:55:04 PM

Page 1

Work Order ID: 66000

Parent Item: D3564-3

Parent Item Name: Wearshoe



Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-08 cc
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

241.5000

1.1

6.947368

12.1



304/316 Sheet .063



12.1-2-2

Location

Loc Qty

Loc Code

MAT

241.5

111323

0

116623

241.5

116623

11

DART AEROSPACE LTD		Work Order: <i>6100</i>
Description: Wearshoe		Part Number: D3564-3
Inspection Dwg: D3564	Rev: D	Page 1 of 1

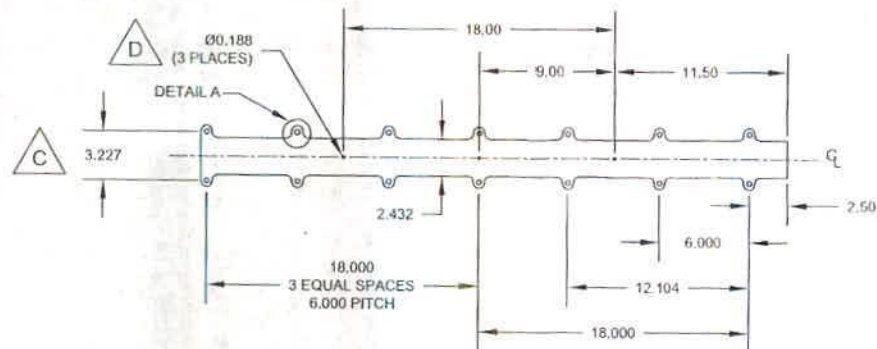
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

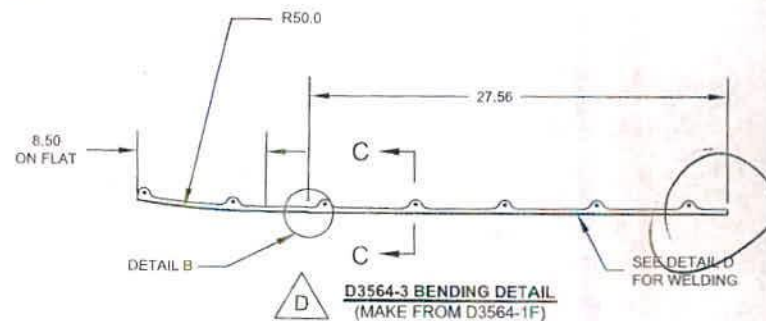
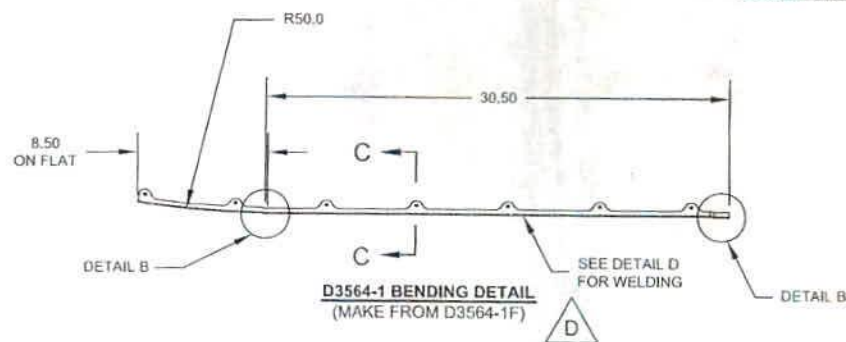
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.226	X		V IR02	
2.432	+/-0.010	2.439	X		V	
2.50	+/-0.030	2.50	X		V	
6.000	+/-0.010	6.00	L		T IR01	
12.104	+/-0.010	12.104	b		T	
18.000	+/-0.010	18.000	X		T	
18.000	+/-0.010	18.00	b		T	
18.00	+/-0.030	18.00	b		T	
9.00	+/-0.030	9.00	7		T	
11.50	+/-0.030	11.50	L		T	
0.300 x 0.300	+/-0.010	304 x 309	L		V	
Ø0.188	+0.005/-0.001	191	X		V	
R0.375	+/-0.010	0.375	X		V	
0.063	+/-0.010	0.060	X		L	

Measured by: <i>IB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>11-2-2</i>	Date: <i>11/02/02</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DC <i>AF</i>	<i>DA</i>



D3564-1F FLAT PATTERN



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C-C

WEIGHTS:

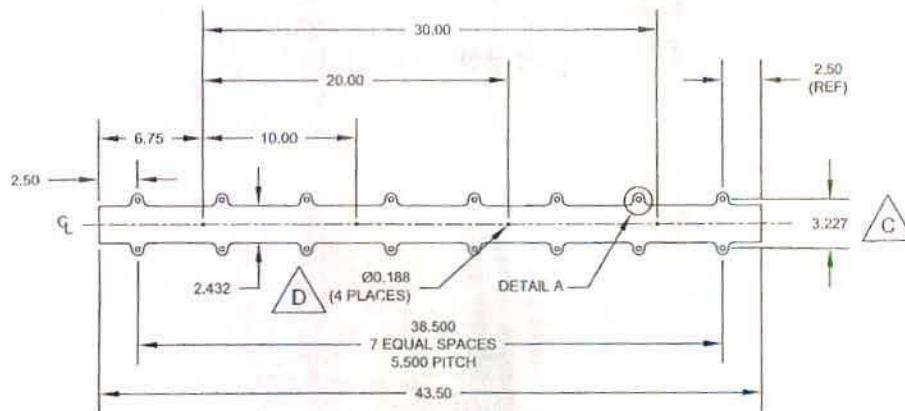
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B5,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	07.08.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

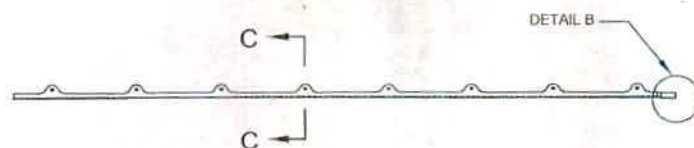
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3564	REV. D SHEET 1 OF 3
TITLE WEARSHOE	SCALE 1:8

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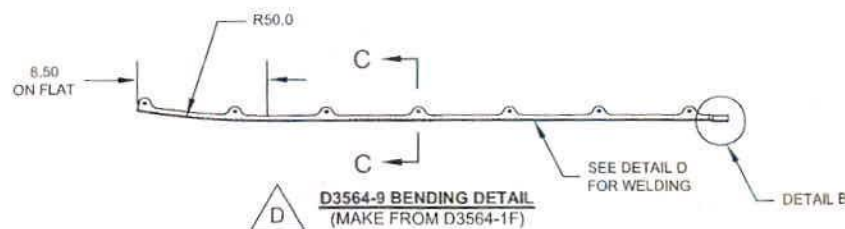
RELEASED
07.09.04



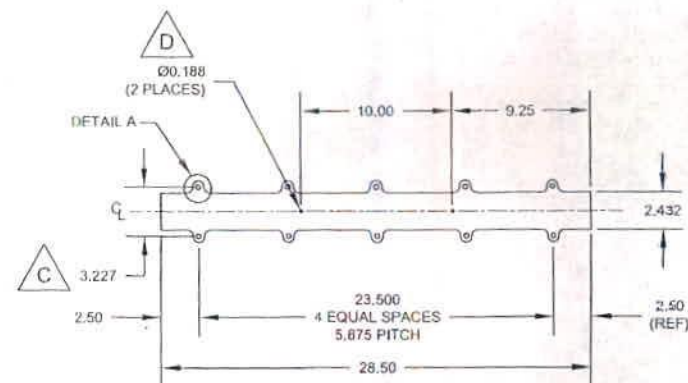
D3564-5F FLAT PATTERN



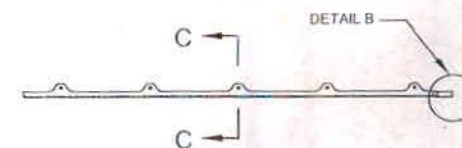
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



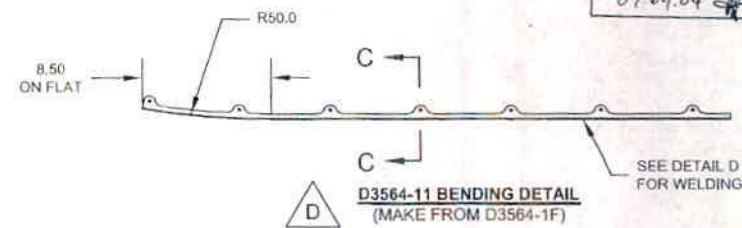
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

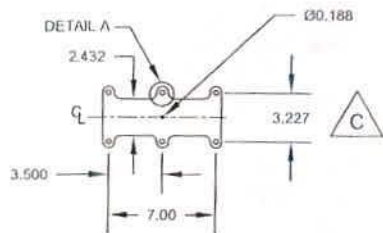


D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

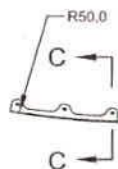
RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD.	

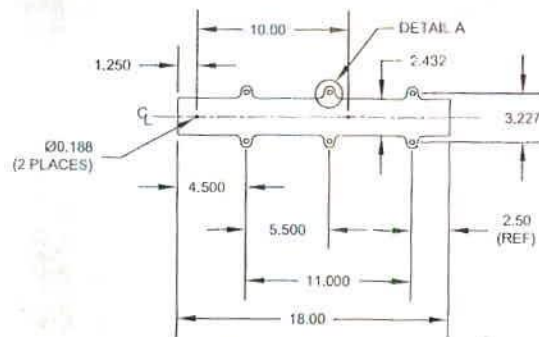
66000



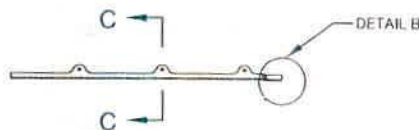
D3564-13F FLAT PATTERN



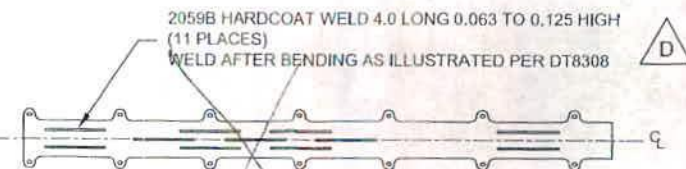
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



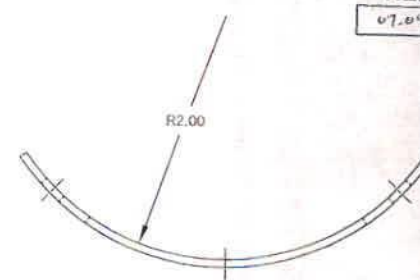
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



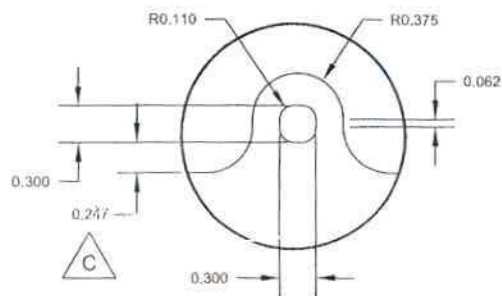
DETAIL D
(D3564-1/3/9/11 WELDING DETAIL)

RELEASED

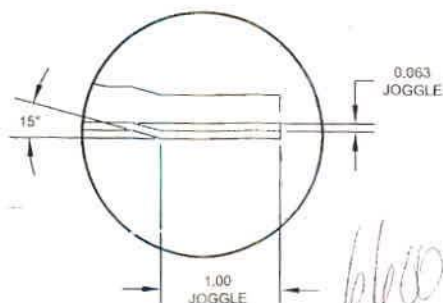
07.07.04



SECTION C-C
SCALE 1:1

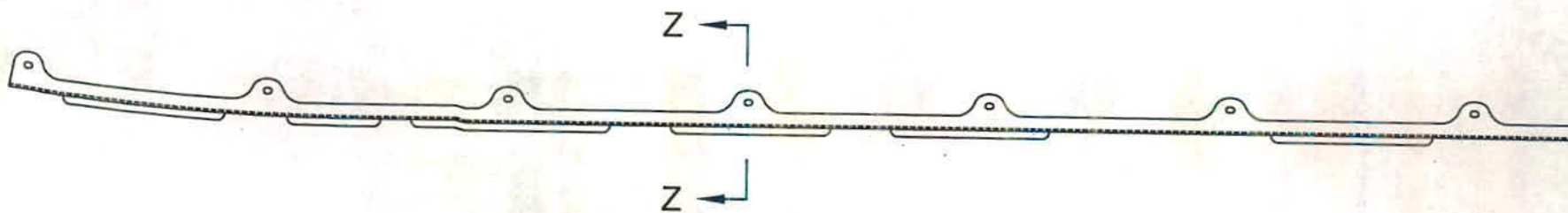


DETAIL A
SCALE 1:1

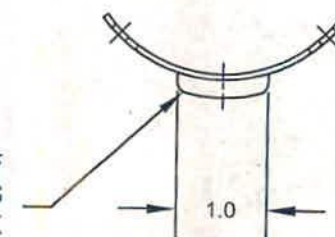


DETAIL B
SCALE 1:1

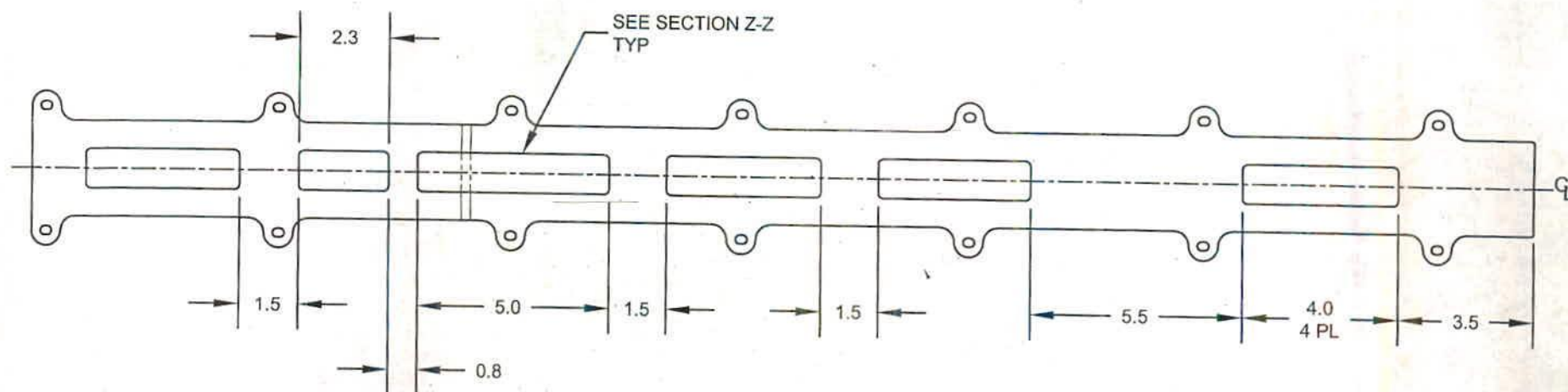
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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
0.188 TO 0.250 THICK



SECTION Z-Z



DETAIL D
(D3564-3 CUSTOM WELDING DETAIL)